

49

DART AEROSPACE LTD	Work Order:	21832
Description: Latch Bracket	Part Number:	D2583
Drawing: D2583 Rev. B	Qty:	197 200

0

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	df	04.11.04	200
2	METAL	Cut blanks: 10.56" x 3.188" Note: 1 Blank makes 2 parts Material: 5052-H32 0.040" thick. Grain offset 10° along 3.188"			
3	CNC	Machine as per folio D2583	mk	04/11/05	200
4	QC	Inspect Level 2	mk	04/11/05	200
5	METAL	Deburr	BE	04/11/11	200
6	METAL	Form on CNC Brake as per Dwg D2583	Z	04/11/16	200
7	METAL	Acid etch and alodine as per QSI 005 4.1	Z	04/11/16	200
8	QC	Inspect Level 5	MM	04/11/18	200
9	FINISHING	Powder Coat White (Ref. 4.3.5.1)as per Dart QSI 005 4.3	MM	04/11/18	200
10	QC	Inspect Level 3	CZ	04/11/19	197
11	STORES	Identify and stock	CZ	04/11/19	197
12	EXPEDITING	Close W/O Cost / part: 3.03 54c 04/11/22 (197) 3.03	df	04.11.22	197

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue		
B	99.02.16	Re-format	DM	
C	00.11.01	Removed P/O for Powder Coat- in house process	DM	L

RELEASED

 DEC 1 8 2000

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21832
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>mg</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	04/11/05	Date:	04/11/05	Date:	N/A

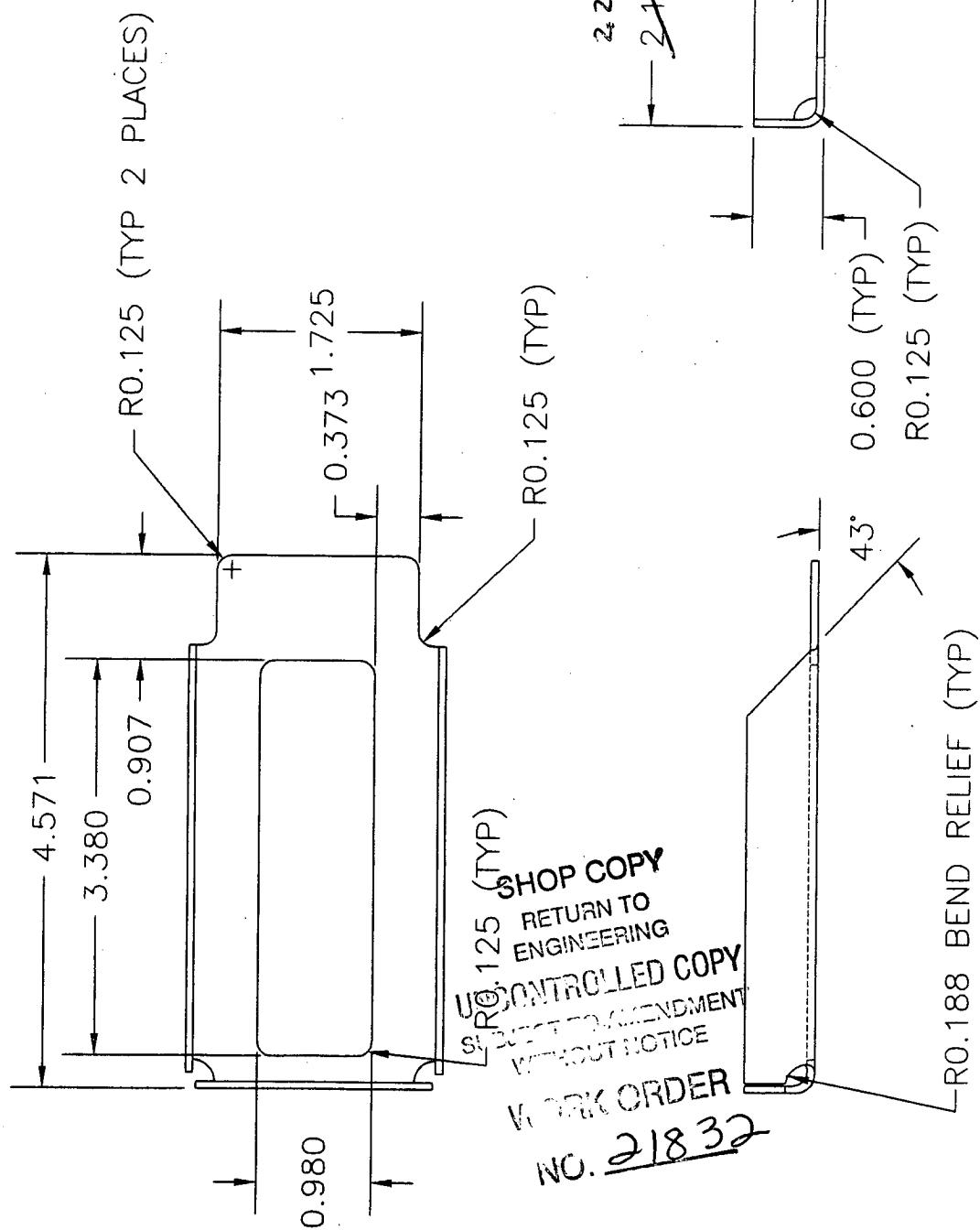
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	

RELEASED

H:\FORMS\Quality Assurance\approved QA\FAI revD

DARTA COPY IS
MAILED

DESIGN MIKE M.	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2583
DATE 99.02.22		TITLE LATCH BRACKET
A	96.07.10	SCALE 2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)

RELEASED
(*KE 99.02.25*)

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 02, 2004
02:36 pm

Work Order No	:	0021832	Department Code:
Project Name	:	D2583	Burden Flags : NNNNNNNN
Project For	:	WK449	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2583	Invoice Number :
Description	:	Latch Bracket	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	100	
Amount Done	:	0	Order Entry No :
Start Date	:	11-02-04	OE Value : 0.00
Est Finish Date	:	11-30-04	
Act Finish Date	:		Est Margin : 0.000%
Drawings Rqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00